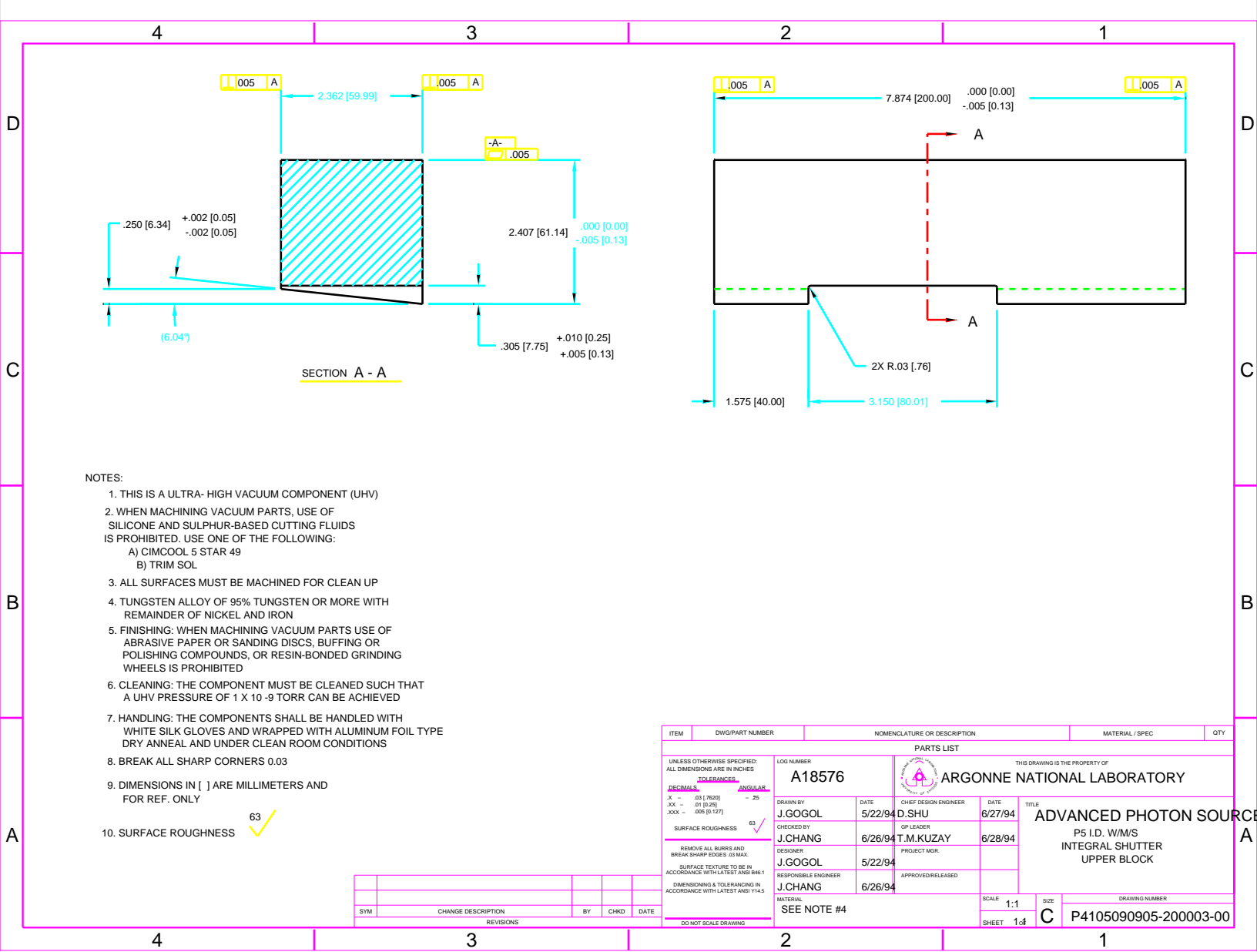


(Ø	PLOT SCALE: 1=1	DWG. SCALE: 1	A18576
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- NOTES:
1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
 2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
 3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
 4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON
 5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
 6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1 X 10 -9 TORR CAN BE ACHIEVED
 7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
 8. BREAK ALL SHARP CORNERS 0.03
 9. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
 10. SURFACE ROUGHNESS 63

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS				
.X - .03 [.7620]				
.XX - .01 [.254]				
.XXX - .005 [.127]				
SURFACE ROUGHNESS				
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
LOG NUMBER				
A18576				
THIS DRAWING IS THE PROPERTY OF				
ARGONNE NATIONAL LABORATORY				
ADVANCED PHOTON SOURCE				
P5 I.D. W/M/S				
INTEGRAL SHUTTER				
UPPER BLOCK				
DRAWN BY				
J.GOGOL				
DATE				
5/22/94				
CHECKED BY				
J.CHANG				
DATE				
6/26/94				
DESIGNER				
J.GOGOL				
DATE				
5/22/94				
RESPONSIBLE ENGINEER				
J.CHANG				
DATE				
6/26/94				
MATERIAL				
SEE NOTE #4				
SCALE				
1:1				
SIZE				
C				
DRAWING NUMBER				
P4105090905-200003-00				